

Date: Tuesday, 18/12/2007 7:55:46 AM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36401
 Estimate Number : 10872
 P.O. Number :
 This Issue : 18/12/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : PURCHASED PARTS
 Previous Run : 35651

Drawing Name : PANEL

Part Number : D32452
 Drawing Number : D3245 REVB
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 10/01/2008

Qty: 2 Um: Each

Written By :
 Checked & Approved By :
 Comment : Est. A 04.07.07 New issue KJ/JLM
 Est Rev:b ECN 1052 07-10-31 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



6.7536



Comment: Qty.: 0.8442 sf(s)/Unit Total : 5.0652 sf(s)

304/316 .032 Sheet

Batch: 106419 IB 07-12-18

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3245 ****prog.D3245-1/-2****

Dwg Rev: B IB 07-12-18

Prog Rev: B

2-Deburr if necessary IB 07-12-18

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-12-18



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

6 4/12/10 (77)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

C'sink as per Dwg D3245

Form D3245-1 as per Dwg D3245 Identify as D3245-1 2

ml 08/03/19 x 20

SS 03/03/14

Process Sheet

er: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 36401

Part Number: D32452

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/03 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

S 08/09/02

(2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



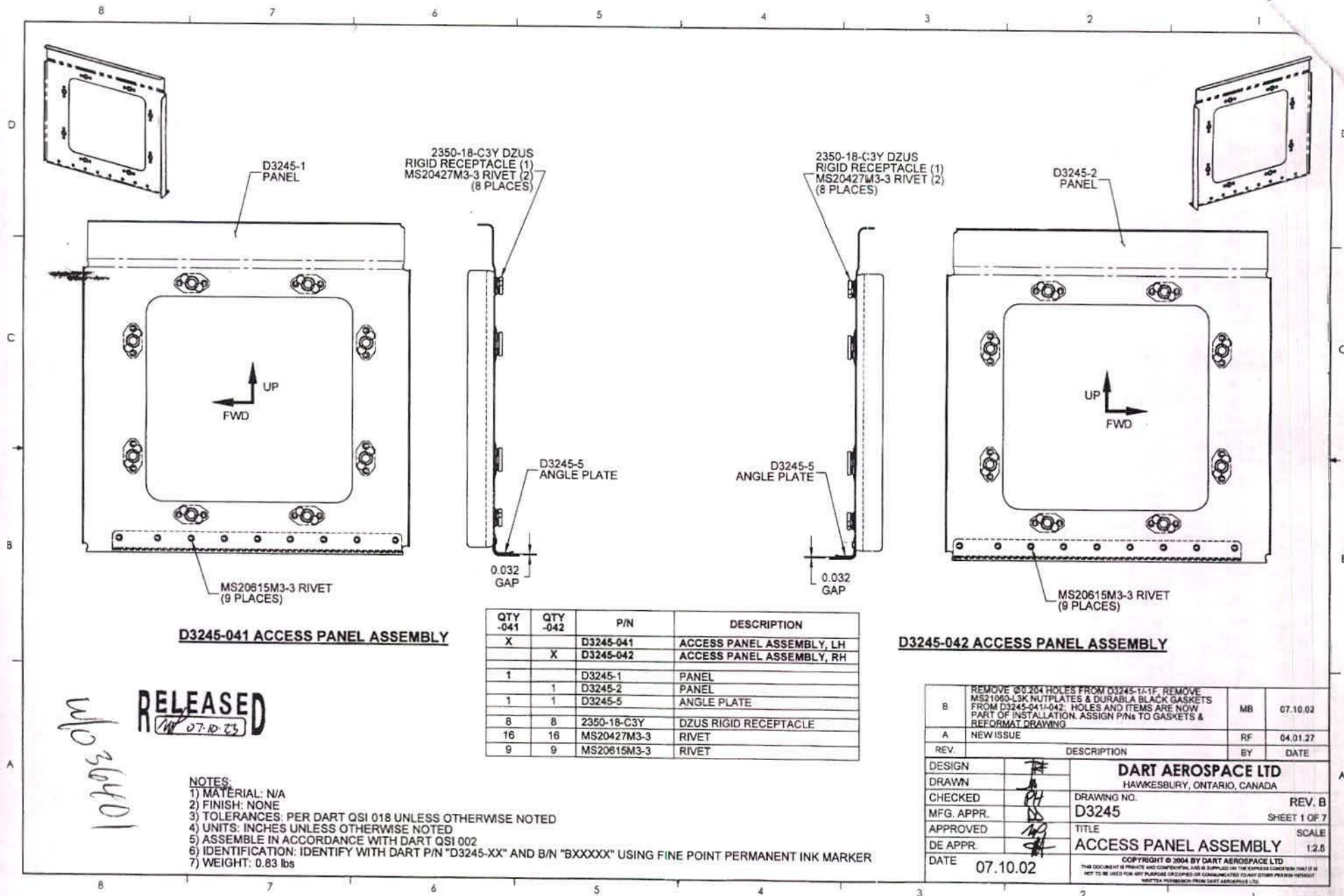
Comment: FINAL INSPECTION/W/O RELEASE

08/09/03

Job Completion



MF 08-09-03



D3245-041 ACCESS PANEL ASSEMBLY

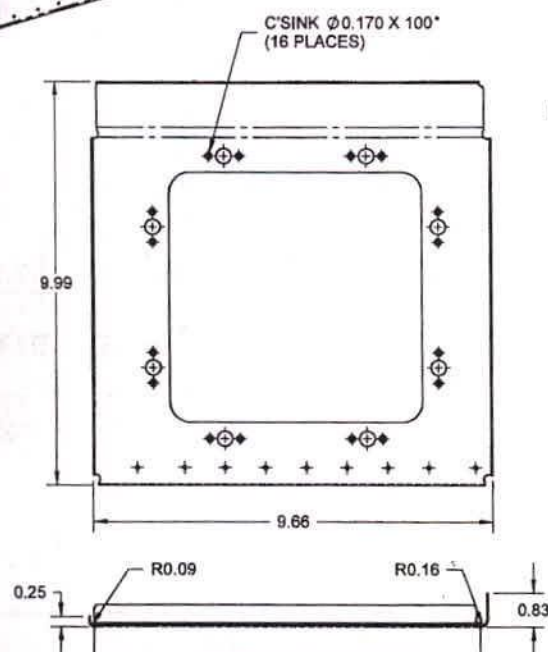
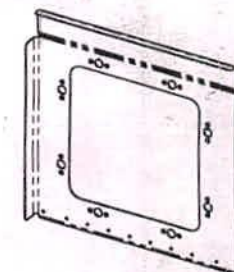
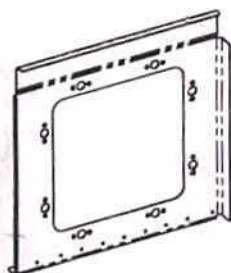
D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

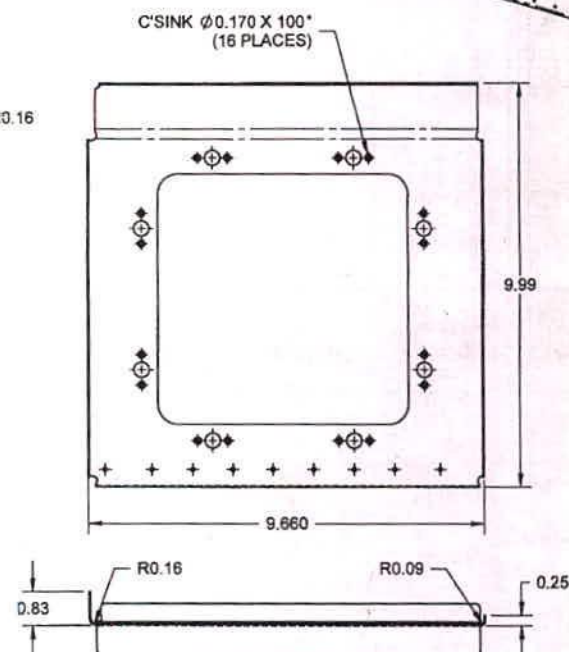
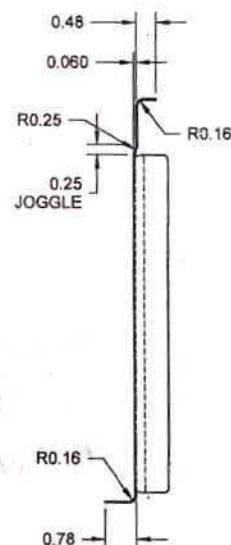
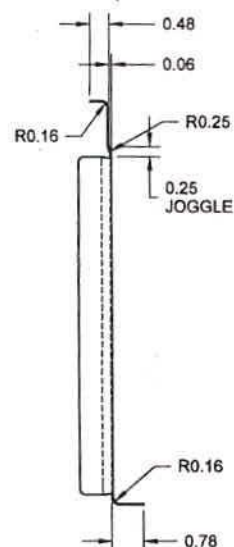
RELEASED
107-10-23

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.83 lbs

B	REMOVE 0.032 HOLES FROM D3245-1/-2. REMOVE MS21060-1-3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3245	SHEET 1 OF 7
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	1:2.5
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		



D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH

RELEASED
107-10-23

NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs


DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3245	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY	1:3
DATE	07.10.02	<small> COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	IB
Date:	07-12-18

Audited by:	
Date:	7/12/19

Prototype Approval:	<i>[Signature]</i>
Date:	<i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	